

Work Order ID 69640

Friday, May 13, 2011 10:02:01 AM



Page 1

Item ID: D350-607-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Basket

Start Date: 5/13/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*AP*Date: *11-05-12*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D350-607-1	A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-607-043 CHG005
PRINT DWG PAGE: 41/42 OF 162*Sub 601**HA for CL 11-5-30
(Label only)*

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/5/30 SP

120

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D350-607
Seal Support Gusset with Sikaflex -291
Batch: *M116945*
Exp Date: *12/01/15**SP 11/06/01 @*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69640

Friday, May 13, 2011 10:02:01 AM



Page 2

Item ID: D350-607-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Basket

Start Date: 5/13/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

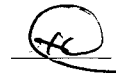
QC5- Inspect part completeness to step on W/O

0.00

S u l o g 6 0 1

0.00

Memo



140



Packaging

Packaging

Pick Kit

0.00

0.00

Memo

11/13/3028

150



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

S u l o g 6 0 1

0.00

Memo



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 69640

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Page 3

Item ID: D350-607-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Basket

Start Date: 5/13/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-607-043

Location: _____

90 11/6/01

170

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

CK 11/06/01

ME
11-05-01

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Friday, May 13, 2011 10:02:07 AM

Page 1

Work Order ID: 69640

Parent Item: D350-607-043

Parent Item Name: Heli-Utility-Basket



Start Date: 5/13/2011

Required Date: 5/23/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:E as Per DSI9318 06-01-24 JLM
 IPP Rev:F ECN1068 07-12-21 DD verified by:ec IPP rev:G as
 per ecn10-545 DD 10.04.19 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2728-3 		Manufactured	No			110	Each	0.0000	2	2			
Dart Logo label													
D350-607-241 	CHC7001	Manufactured	No			140	Each	3.0000	1	1			
Basket Clamp Assembly													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG022				3					
				69365				3					
D2022-101 		Manufactured	No			110	Each	60.0000	5	5			
Spacer													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST504				60					
				67768				60					
D2221 		Manufactured	No			110	Each	0.0000	1	1			
350 Basket Base													
D2258-200 		Manufactured	No			110	Each	12.0000	1	1			
Placard 200lb													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST505				12					
				64284				2					
				68928				10					

6

8

5

B69767 (12)

5/11/06/01

11/5/30

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Page 2

Work Order ID: 69640

Parent Item: D350-607-043





Parent Item Name: Heli-Utility-Basket



Start Date: 5/13/2011



Required Date: 5/23/2011



Start Qty: 1.00

Required Qty: 1.00

D2332-041	Manufactured	No	110	Each	0.0000	1	1
							B68830
Lid Prop Assembly 6.69" long							
D2530	Manufactured	No	110	Each	7.0000	1	1
							SP
Handle Weldment							

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			ST506	7			
			66563	1			
			68363	6			
D2535	Manufactured	No		110	Each	39.0000	2
							2
Spring							

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			ST504	39			
			66764	39			
D2537	Manufactured	No		110	Each	30.0000	2
							2
Bushing							

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			ST504	30			
			66972	30			
D2931	Manufactured	No		110	Each	672.0000	2
							2
Bumper							

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			ST504	672			
			46064	672			

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 3

Work Order ID: 69640

Parent Item: D350-607-043

Parent Item Name: Heli-Utility-Basket

Start Date: 5/13/2011

Required Date: 5/23/2011

Start Qty: 1.00

Required Qty: 1.00

D2989-041 Manufactured No



Basket Lid Assembly

D2989-043 Manufactured No



Basket Lid Assembly

AN3-16A Purchased No



Bolt

110 Each 0.0000 1

B69768 (10X)



1 5/11/06/01

110 Each 0.0000 1

B69769 (10X)



1 5/11/06/01

110 Each 149.0000 2



2

Location

Loc Qty

Loc Code

ST352

149

116419

49

117441

100

AN4-13A Purchased No



Bolt

110 Each 245.0000 2



2

Location

Loc Qty

Loc Code

ST357

245

117628

245

AN4-22A Purchased No



Bolt

110 Each 235.0000 7



7 11/5/06/01

Location

Loc Qty

Loc Code

ST359

235

114784

85

116419

50

117313

100

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Page 4

Work Order ID: 69640

Parent Item: D350-607-043

Parent Item Name: Heli-Utility-Basket

Start Date: 5/13/2011

Required Date: 5/23/2011

Start Qty: 1.00

Required Qty: 1.00

AN5-17A Purchased No 110 Each 108.0000 4
Bolt

Location

Loc Qty

Loc Code

ST339

108

116590

28

117313

30

117619

50

MS20600-AD4W3 Purchased No 110 Each 1,365.000 2
Cherry Rivets

Location

Loc Qty

Loc Code

ST321

1040

111636

340

117505

500

117601

200

WA018

325

107939

325

AN960JD416 NAS1149D0463J Purchased No 110 Each 0.0000 14
Washer

AN960JD416L NAS1149D0416J Purchased No 110 Each 3.0000 2
Washer

Location

Loc Qty

Loc Code

FP-B

3

110153

3

AN960JD516 NAS1149D0563J Purchased No 110 Each 0.0000 4
Washer

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 5

Work Order ID: 69640

Parent Item: D350-607-043

Parent Item Name: Heli-Utility-Basket



Start Date: 5/13/2011

Required Date: 5/23/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD8 NAS1149DN832J Purchased

No

110

Each

0.0000

2

2



Washer

NAS1515H4

Purchased

No

110

Each

92.0000

2

2



Washer

Location

Loc Qty

Loc Code

ST277

92

111525

2

116169

40

117460

50

AN970-4

Purchased

No

110

Each

95.0000

4

4



Washer

Location

Loc Qty

Loc Code

ST344

14

115936

14

ST349

81

116900

31

117317

50

MS21042L3

Purchased

No

110

Each

2,259.000

2

2



Nut

Location

Loc Qty

Loc Code

ST300

2259

116391

11

116540

282

116549

766

117441

800

117601

400

Friday, May 13, 2011 10:02:09 AM

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, May 13, 2011 10:02:09 AM

Page 6

Work Order ID: 69640

Parent Item: D350-607-043

Parent Item Name: Heli-Utility-Basket



Start Date: 5/13/2011

Required Date: 5/23/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

110

Each

4,971.000

9



Nut

Location

Loc Qty

Loc Code

ST300

4971

114718

16

116823

1155

117441

3000

117601

800



9
SP

MS21042L5

Purchased

No

110

Each

1,279.000

4



Nut

Location

Loc Qty

Loc Code

ST300

1279

116105

319

116548

260

117441

500

117591

100

117611

100



4
11/13/308

4
Y

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69640

D350-607-1
Page 20 of 22

6.0 PARTS LIST

6.1 D350-607-041/-041A/-043/-043A HELI-UTILITY-BASKET™

11-05-13

Qty -041	Qty -041A	Qty -043	Qty -043A	Qty -241	Part Number	Description
X					D350-607-041	HELI-UTILITY-BASKET
	X				D350-607-041A	HELI-UTILITY-BASKET
		X			D350-607-043	HELI-UTILITY-BASKET
			X		D350-607-043A	HELI-UTILITY-BASKET
1	1	1	1	X	D350-607-241	BASKET CLAMP KIT INSTALLATION
2	2	5	5		D2022-101	SPACER
1	1	1	1		D2221	BASKET BASE ASSEMBLY
				4	D2230-1	LUG
				4	D2230-3	CLAMP
1	1	1	1		D2258-200	LABEL
1	1	1	1		D2324	STRUT
1		1			D2332-041	PROP ASSEMBLY
1	1				D2512	BASKET LID ASSEMBLY
1	1	1	1		D2530	HANDLE WELDMENT
2	2	2	2		D2535	SPRING
2	2	2	2		D2537	BUSHING
				8	D2732-030	RUBBER CUSHION
2	2	2	2		D2931	BUMPER
		1	1		D2989-041	BASKET LID ASSEMBLY (OUTSIDE)
		1	1		D2989-043	BASKET LID ASSEMBLY (INSIDE)
	1				D350-607-141	AUTOMATIC LID OPENER INSTL
			1		D350-607-143	AUTOMATIC LID OPENER INSTL
2	2	2	2		AN3-16A	BOLT
2	2				AN4-7A	BOLT
5	5	5	5		AN4-12A	BOLT
		2	2		AN4-13A	BOLT
				8	AN4-15A	BOLT
1		7	5		AN4-22A	BOLT
1					AN4-24A	BOLT
4	4	4	4		AN5-17A	BOLT
2	2	2	2		MS20600AD4W3	RIVET (OR CR9163-4-3)
12	12	24	24	16	NAS1149D0463J	WASHER (OR AN960JD416)
2		2			NAS1149D0416J	WASHER (OR AN960JD416L)
4	4	4	4		NAS1149D0563J	WASHER (OR AN960JD516)
2	2	2	2		NAS1149DN832J	WASHER (AN960JD8)
		2	2		NAS1515H4	WASHER
4		4			AN970-4	WASHER
2	2	2	2		MS21042L3	NUT (OR MS21042-3)
9	7	14	12	8	MS21042L4	NUT (OR MS21042-4)
4	4	4	4		MS21042L5	NUT (OR MS21042-5)

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Revision: A
Date: 10.03.10

Dart Aerospace Ltd

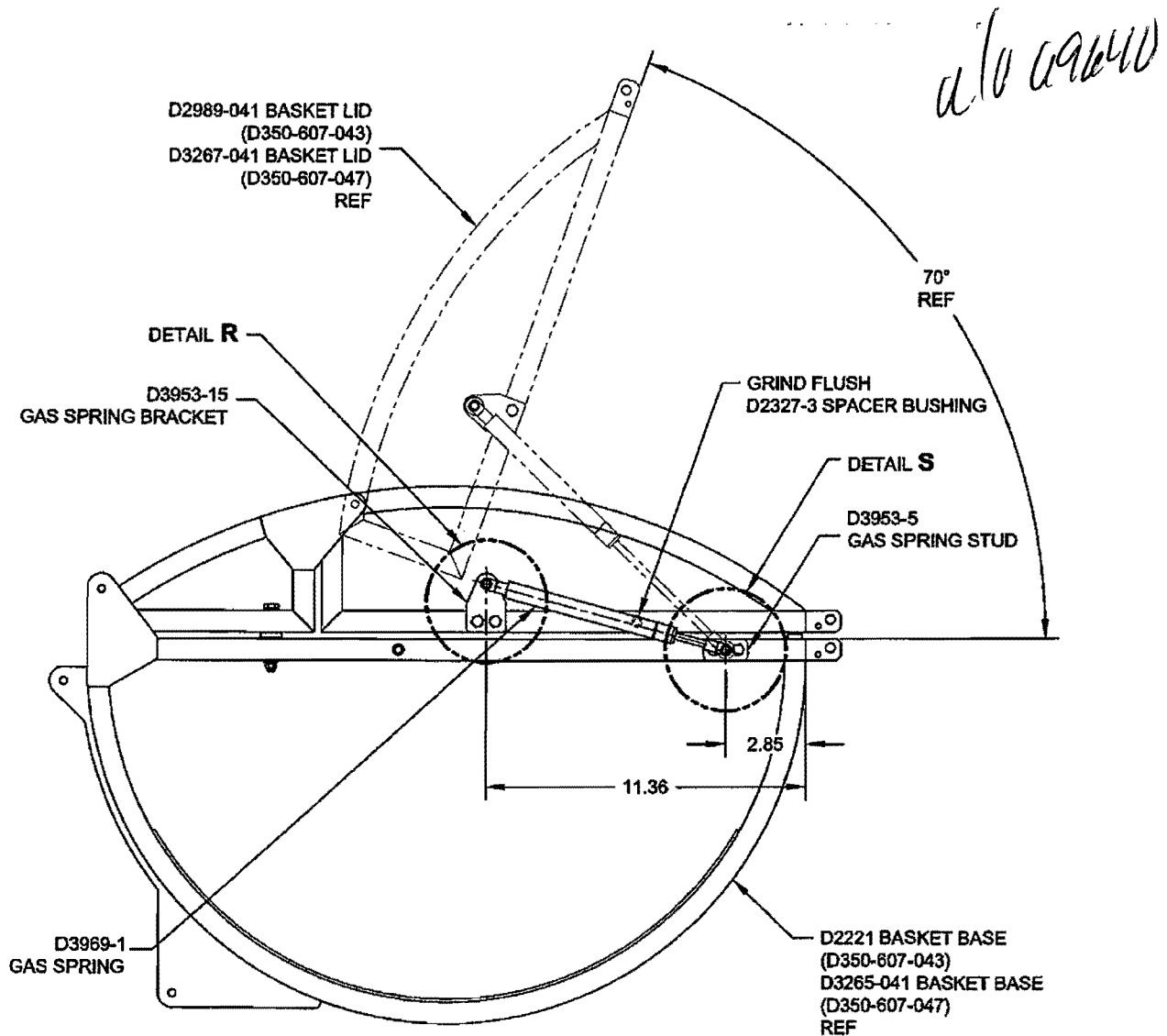
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



D350-607-143 AUTOMATIC LID OPENER INSTALLATION

(1 END ONLY)

Figure 9a – Automatic Lid Opener Installation

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Revision: **A**

Date: 10.03.10

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NOTE: Date & initial all entries

u/069640

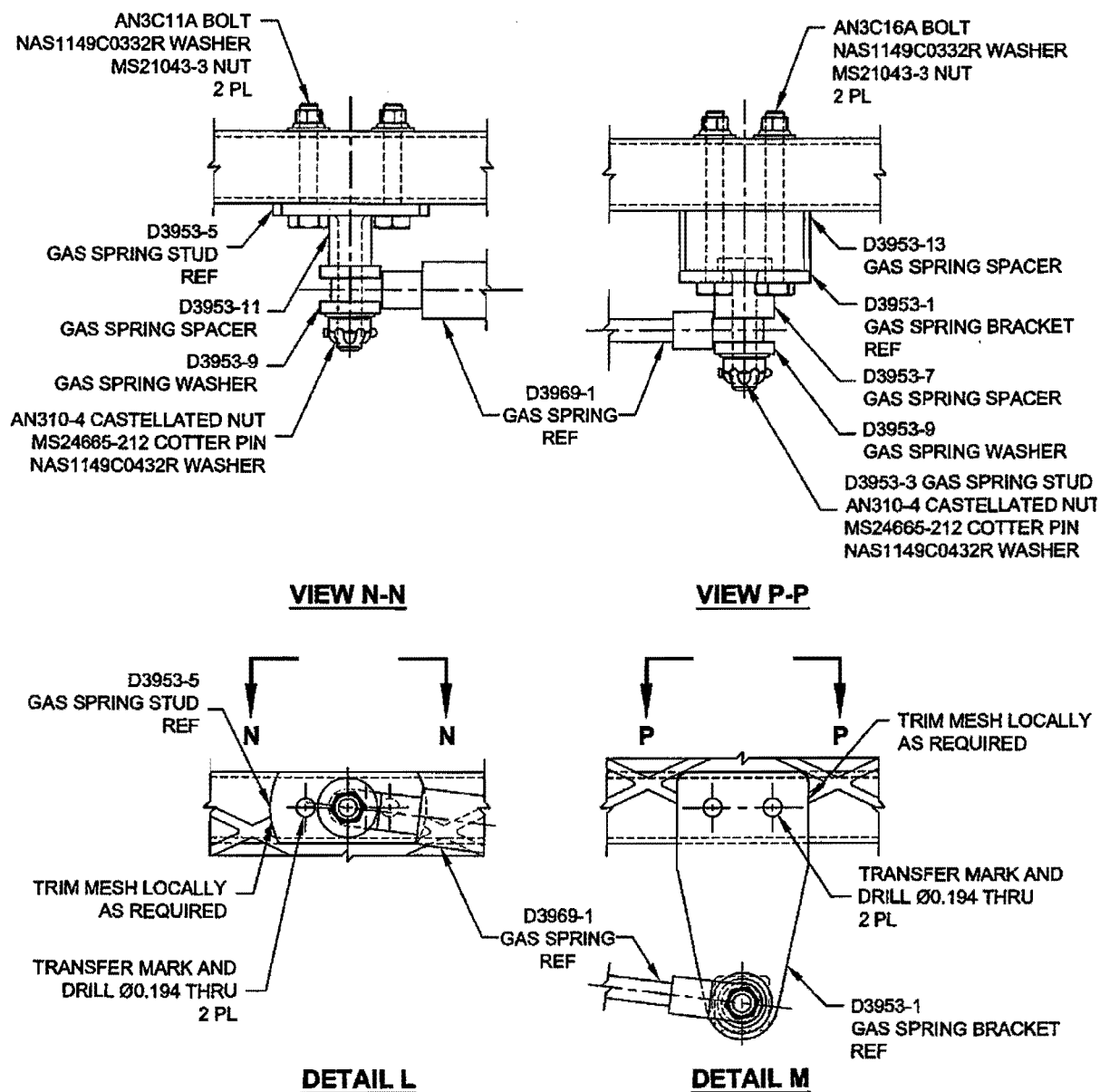


Figure 8b – Automatic Lid Opener Installation

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

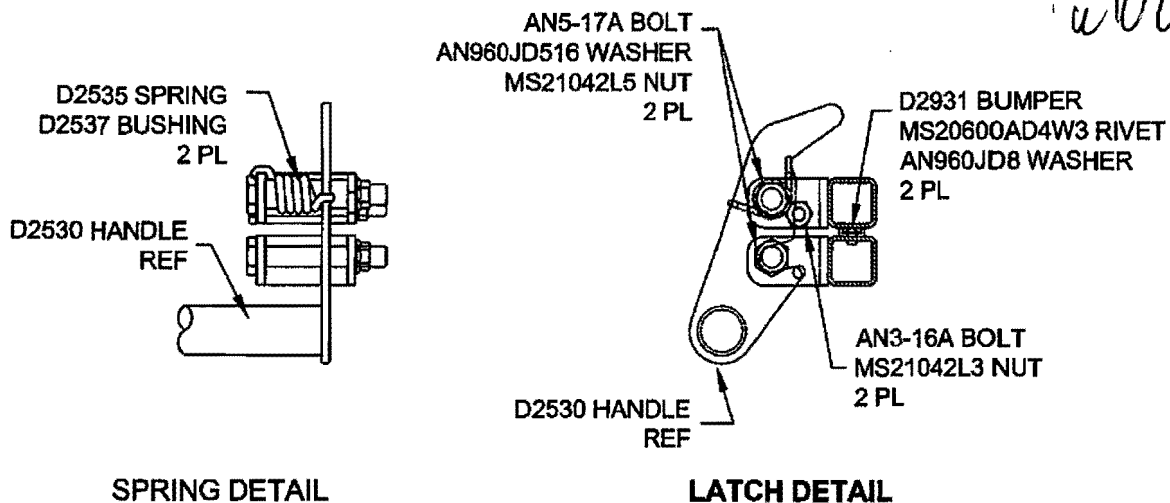
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

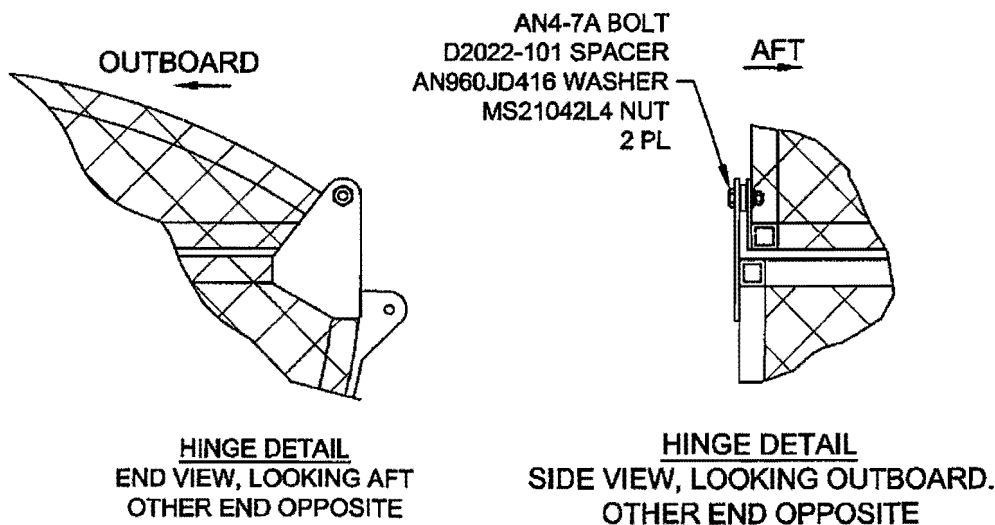
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

u/b 9640



DETAIL J:
HANDLE WELDMENT



DETAIL H:
HINGE

Figure 7 – Basket Replacement Parts

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Revision: **A**
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W/O:		WORK ORDER CHANGES					
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